

Date: Tuesday, 27/01/2009 11:11:09 AM
 User: Julie Dawson

Process Sheet

Split Reqty / on - 2w/o
 20902-15

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOOR WINDOW
 Job Number : 45270 -1
 Estimate Number : 10848
 P.O. Number :
 This Issue : 27/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 41796
 Part Number : D3295041
 Drawing Number : D3295 REV D
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 10/02/2009 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : JUD 09.01.27
 Comment : Est. C 05.06.20 D3295-1 no longer made in-house KJ/JLM
 Est Rev:D Added DT8822 07-03-20 JLM
 Est Rev:E Returned Manufacturing In House 07-06-26 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MLEXS125 9034 01 1/8" 9034 Lexan Sheet



80



Comment: Qty.: 1.3020 sf(s)/Unit Total: 5.2080 sf(s)
 1/8" Thick Lexan 9034 sheet
 Batch: 106173 B 9-1-31

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3295
 Dwg Rev: B B 9-1-31
 Prog Rev: B

16

PD

2-Remove plastic and wrap in saran wrap.

2-Deburr if necessary

B 9-1-31

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 9-1-31



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK







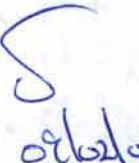





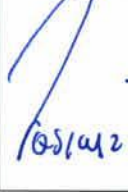


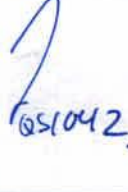
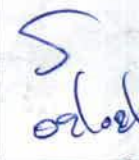
Comment: SECOND CHECK

S 01/02/02

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3295-041 PAR #: N/A Fault Category: Prod/Prod Assy NCR: Yes No DQA: 12 Date: 09/02/25
 Resolution: re-work Disposition: re-work QA: N/C Closed: _____ Date: _____

NCR: <u>45270-1</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/2/2	# 20	During inspection found Qty ③ windows with a Step cut from water jet RC Machine malfunction.		Blend out the step. - parts acceptable within tolerance.	 09/02/17			
9/2/2	# 20	During inspection found Qty ④ window with many many scratches.		Scrap and Destroy Qty ④ - no Repair attempts	 09/02/17			
		on it in the field of view RC. improper storage after water jet. Sand in between parts.		were made - Ensure windows are boxed off to remove abrasive prior to stacking.	 9-2			

NOTE: Date & initial all entries

Date: Tuesday, 27/01/2009 11:11:09 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR WINDOW

Job Number: 45270

Part Number: D3295041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D3295.
Put window in plastic wrap.

SAD 09-02-19

15

6.0	D27281	Dart Logo label
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Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)
Dart Logo label small
Pick:

Qty	Part Number	Description	Batch
1	D2728-1	Decal	B39012

SAD 09-02-17

14

15

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

09-02-19

need to be re-wrapped

(14) (PTU)

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 51217

AS 09/02/20

9.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/02/23


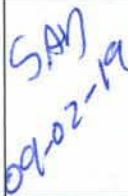



Job Completion



09-02-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3295-041 PAR #: N/A Fault Category: Prod / FAB. ^{med & small}assy NCR: Yes No DQA: D Date: 09/02/25
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/02/25

NCR: <u>45270</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-02-19	7.0	1 window scrap, had a chatter along the surface. R.C: Material defect. very apparent.		Scrap: destroy.	 09-02-19			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45270
Description: Window		Part Number: D3295
Inspection Dwg: D3295	Rev: D	Page 1 of 1

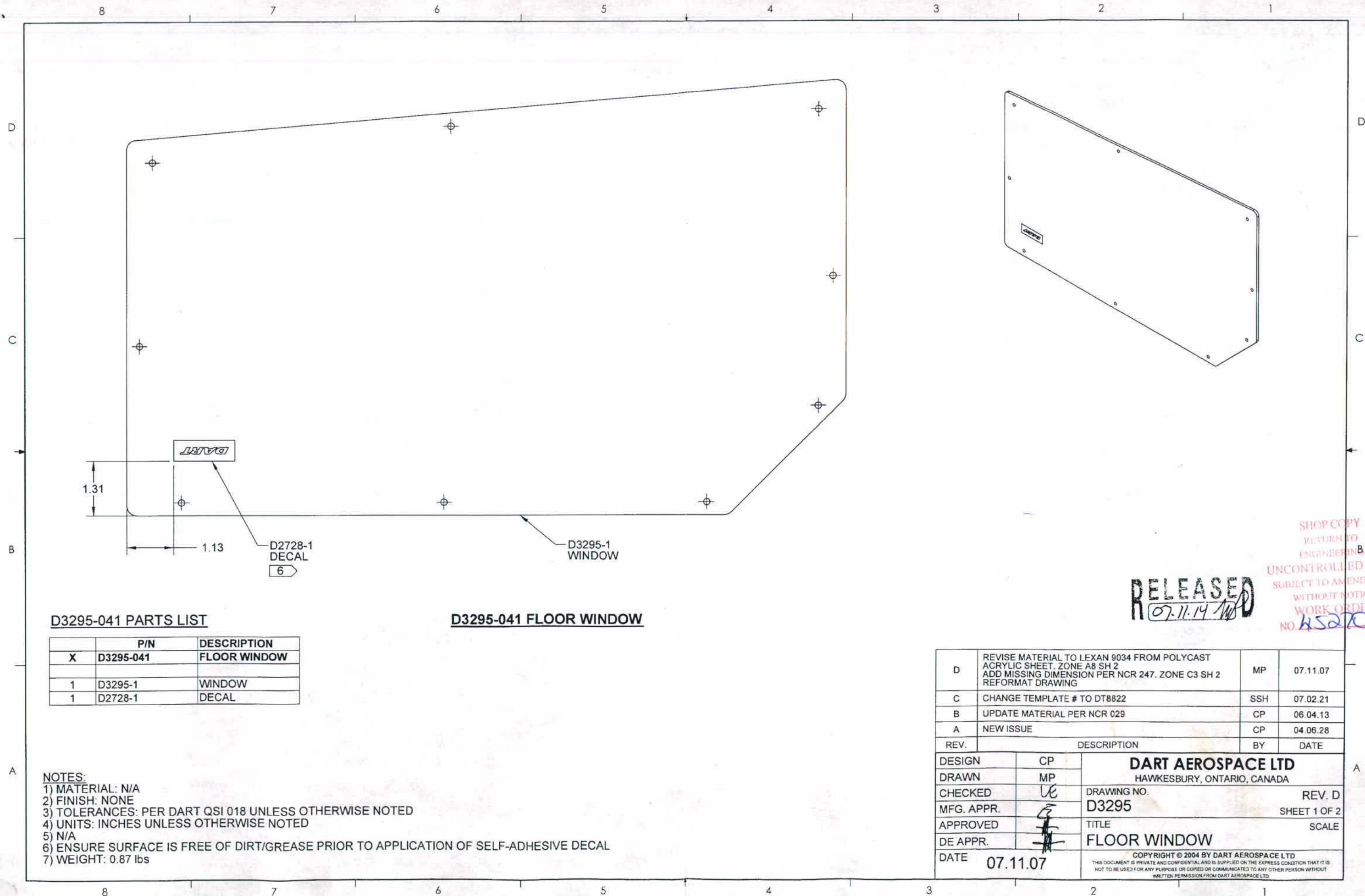
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	.156	*			
17.13	+/-0.030	17.13	*			
10.43	+/-0.030	10.43	✓			
14.35	+/-0.030	14.35	✓			
8.98	+/-0.030	8.983	*			
0.625	+/-0.010	.616	✗			
7.109	+/-0.010	7.107	✗			
15.845	+/-0.010	15.845	✗			
2.308	+/-0.010	2.307	✓			
5.420	+/-0.010	5.419	✓			
9.402	+/-0.010	9.405	✗			
1.312	+/-0.010	1.316	✓			
6.260	+/-0.010	6.254	✗			
12.520	+/-0.010	12.520	✗			
0.313	+/-0.010	.315	✓			
3.750	+/-0.010	3.743	✗			
8.150	+/-0.010	8.151	✗			
9.006	+/-0.010	9.004	✗			
0.125	+/-0.010	.121	✓			

Measured by: IB	Audited by: 5	Prototype Approval:	N/A
Date: 9-1-31	Date: 09/02/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	IB



D3295-041 PARTS LIST

	P/N	DESCRIPTION
X	D3295-041	FLOOR WINDOW
1	D3295-1	WINDOW
1	D2728-1	DECAL

D3295-041 FLOOR WINDOW

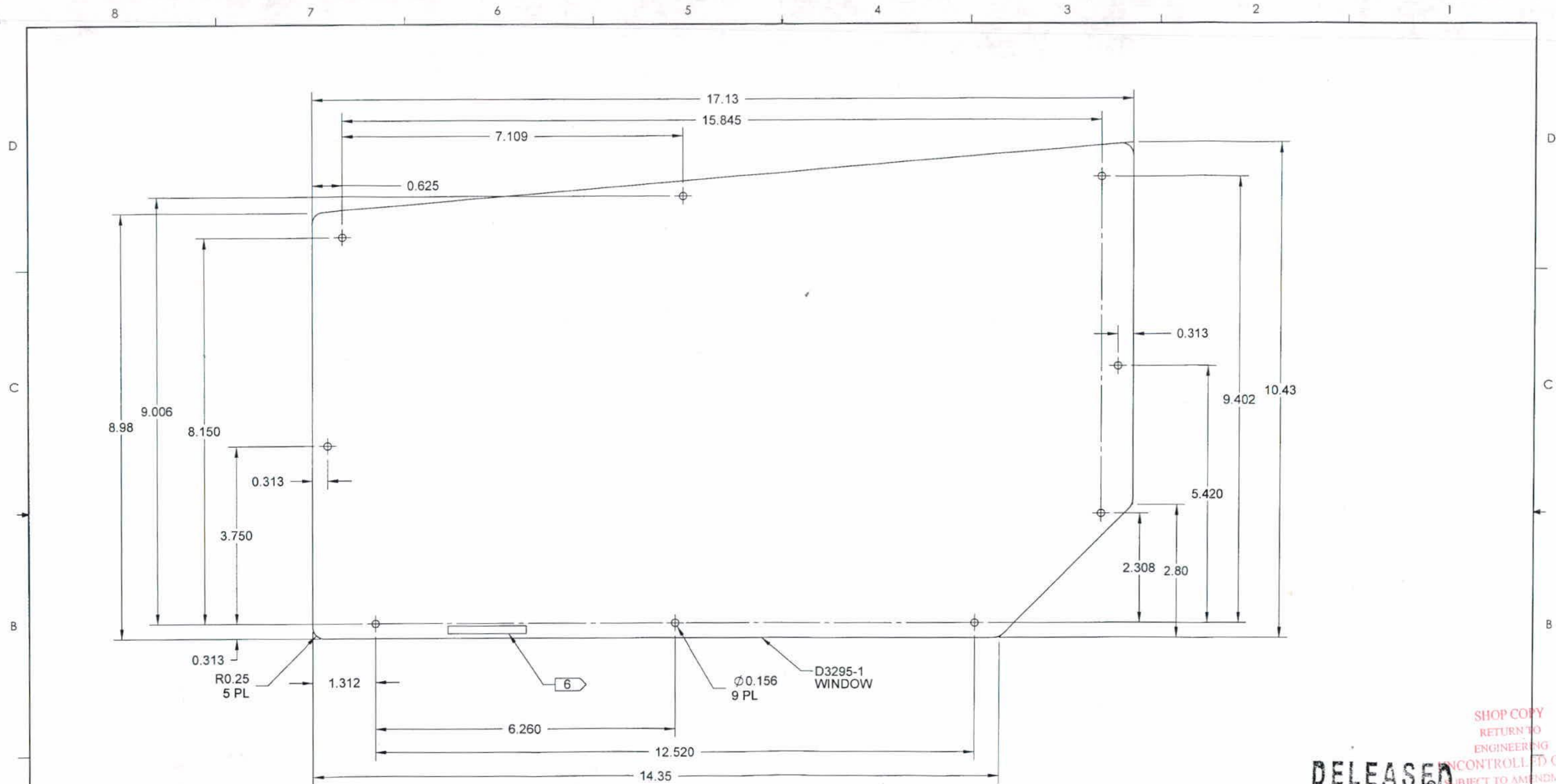
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) N/A
- 6) ENSURE SURFACE IS FREE OF DIRT/GREASE PRIOR TO APPLICATION OF SELF-ADHESIVE DECAL
- 7) WEIGHT: 0.87 lbs

D	REVISE MATERIAL TO LEXAN 9034 FROM POLYCAST ACRYLIC SHEET. ZONE A8 SH 2 ADD MISSING DIMENSION PER NCR 247. ZONE C3 SH 2 REFORMAT DRAWING	MP	07.11.07
C	CHANGE TEMPLATE # TO DT8822	SSH	07.02.21
B	UPDATE MATERIAL PER NCR 029	CP	06.04.13
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED	UE	DRAWING NO.	REV. D
MFG. APPR.	5	D3295	SHEET 1 OF 2
APPROVED	5	TITLE	SCALE
DE APPR.	5	FLOOR WINDOW	
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WORK ORDER
NO. 45270



D3295-1 WINDOW

D3295-1 WINDOW

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK (REF DART SPEC. MLEXS.125-9034-01)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041". USE LETTERS 0.125 TO MAX DEPTH OF 0.005
LOCATE APPROXIMATELY AS SHOWN
- 7) WEIGHT: 0.87 lbs

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED	U	DRAWING NO. D3295	REV. D
MFG. APPR.	E		SHEET 2 OF 2
APPROVED	J	TITLE FLOOR WINDOW	SCALE
DE APPR.	CH		
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